

Date: Monday, 02/03/2009 9:05:16 AM
User: Julie Dawson

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : STEP WELDMENT

Job Number : 46148 - 1

Estimate Number : 10698

P.O. Number :

This Issue : 02/03/2009 S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : SMALL / MED FAB

Previous Run : 44794

Part Number : D34631

Drawing Number : D3463 REV B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 16/03/2009

Qty: 1/2 Um: Each

Written By :

Checked & Approved By : JUD 09.03.02

Comment : EST REV. A 05.11.17 NEW ISSUE EC

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M316TR100W120

316 RD tubing 1.00 x .120w



(2x)

Comment: Qty.: 2.1872 f(s)/Unit Total: 21.8715 f(s)
AISI 316 SS seamless tubing 1.00" OD X 0.120 wall
(M316TR1.00w120)
Batch: M110672

M-L 04/03/16

2.0 BAND SAW

BAND SAW



(2x)

Comment: BAND SAW
Cut blank 25.00 " long

M-L 04/03/16

3.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(2x)

Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Bend as per dwg D3463
2-Trim to length per dwg D3463
3- Deburr

M-L 04/03/16

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.

S 04/03/16 (x2)

5.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
1- Drill as per dwg D3463

H A

09/03/16

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46148

Part Number: D34631

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr as per dwg D3463

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B.A 09/03/16

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 09/03/16 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W/O 46154

EC 9-3-17 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/17

Job Completion



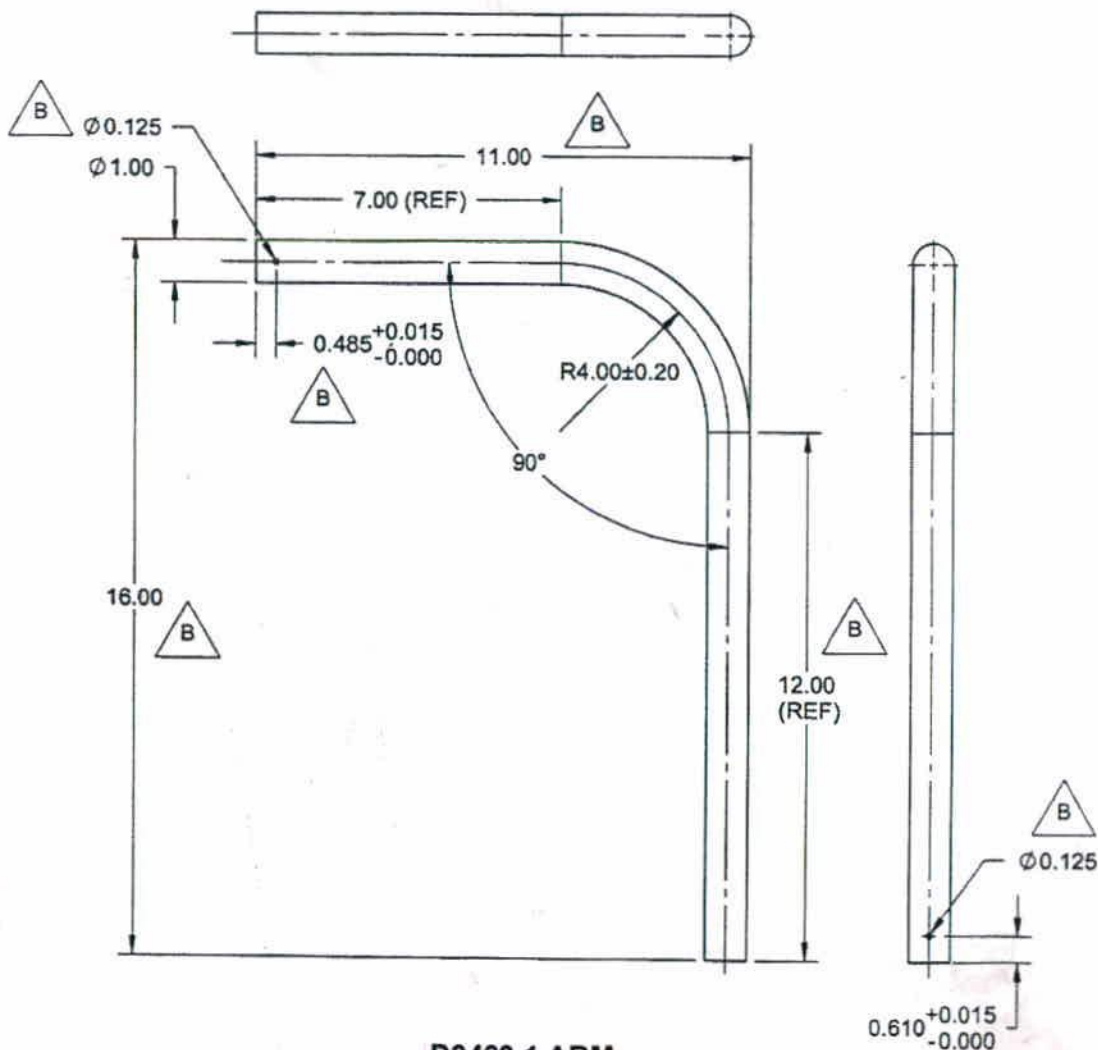
mf 09-03-17



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.09



D3463-1 ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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